

with the wheel. The vertical hole, with the drill guided by bushing *G*, is now drilled in all the handwheels, this hole being drilled into a lug in the spoke held by the two set-screws *B*. When this hole is drilled, the jig is moved over to a horizontal drilling machine, and the hole *D* is drilled in all the handwheels, the jig being clamped to the table of this machine in a manner similar to that on the drill press.

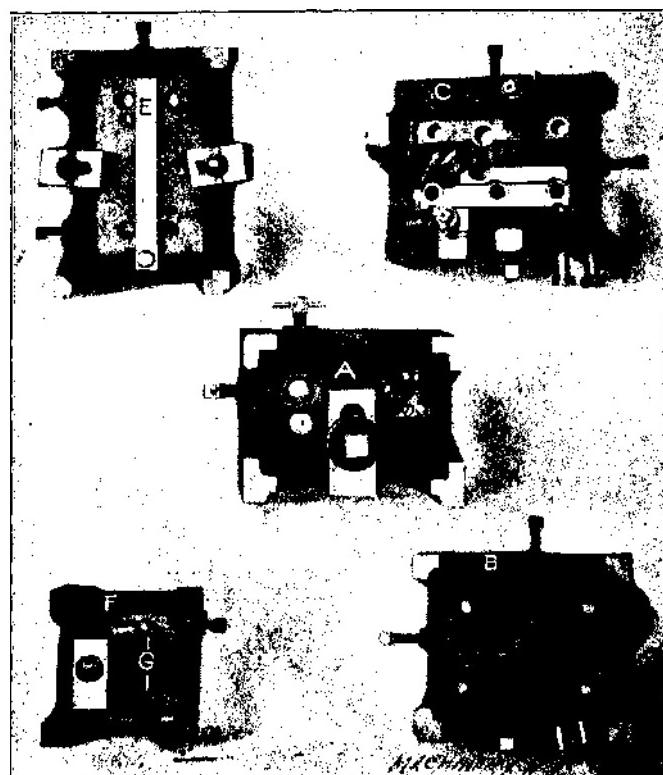


Fig. 20. Miscellaneous Examples of Open Drill Jigs

In Fig. 20, at *A*, an open drill jig of a type similar to those shown in Figs. 11 and 13, is shown. This jig, however, is provided with a V-block locating arrangement. An objectionable feature of this jig is that the one clamping strap is placed in the center of the piece to be drilled. Should this piece be slender, it may cause it to bend,

as there is no bearing surface  
under the